

# Work Order ID 57337

April 5, 2010 3:03:37 PM



Page 1

Item ID: D2873-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate Assembly

Start Date: 05/04/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 19/04/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

*PS*

Date:

*10-4-05*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2873

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 3.700" long

*20 10/04/14*

*20*

*10/04/14*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873 Identify as D2873-3  
Dwg Rev *FA* Folio Rev *FA*

*10.4.14*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*10.4.14*

*20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 57337**

April 5, 2010 3:03:37 PM



Page 2

Item ID: D2873-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate Assembly

Start Date: 05/04/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 19/04/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

cm 10/04/15

20

0

140



Small Fab

Small Fab

Small Fab

Memo

1-Deburr □2- C'sink as per Dwg D2873

0.00

0.00

95 10/04/16 (20)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

810/04/16

wants  
(+20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 57337

April 5, 2010 3:03:37 PM



Page 3

Item ID: D2873-043

Accept



Setup Start



Revision ID:

Item Name: Nut Plate Assembly

Stop



Start Date: 05/04/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 19/04/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*20 i 04/19*

*x20*

*q*

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*20*

*10-4-19*

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D2873 ☐ 2-Identify as D2873-043

*9/5/10/04/19 20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 57337**

April 5, 2010 3:03:37 PM



Page 4

Item ID: D2873-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate Assembly

Start Date: 05/04/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 19/04/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

*S. Colabulzo**count*  
*(x20)*

Memo

0.00

200



Packaging

Packaging

Identify as per dwg & Stock Location: *X-tube*  
*Ass'y*

0.00

0.00

Memo

*m/* *10* *04* *20* *(20)*

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

*10/04/21* *[Signature]**MF*  
*10-4-21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

April 5, 2010 3:03:41 PM

Page 1

Work Order ID: 57337

Parent Item: D2873-043

Parent Item Name: Nut Plate Assembly


Comments: IPP A 05.09.13 New issue KJ/JLM

Start Date: 05/04/2010

Required Date: 19/04/2010

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21075L5  Nut Plate		Purchased	No			100	Each	131.0000	60.0000			

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST303

131

112243

131

M6061T6B0.375X01.00  
0

Purchased

No

180

f

3.6000

6.4905



6061T6 BAR .375 x 1.00

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT01

113325

3.6

3.6

MS20426AD4-6

Purchased

No

180

Each

3,719.000

120.0000



Rivet

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST317

110139

3719

3719

*Handwritten:* 5/10/04/19

*Handwritten:* 60

*Handwritten:* 114352 = 6.1666' 5/10/04/14

*Handwritten:* 5/10/04/19

*Handwritten:* 120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	57337
<b>Description:</b> Radius Block		<b>Part Number:</b>	D2873-3
<b>Inspection Dwg:</b> D2873	<b>Rev:</b> A	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.50	/	/		
2.000	+/-0.010	2.000	/	/		
0.750	+/-0.010	.750	/	/		
1.000	+/-0.010	1.000	/	/		
0.250	+/-0.010	.250	/	/		
1.000	+/-0.010	1.000	/	/		
2.000	+/-0.010	2.000	/	/		
3.000	+/-0.010	3.000	/	/		
Ø0.128	+0.005/-0.001	.130	/	/		
0.359	+/-0.010	.359	/	/		
Ø0.316	+0.006/-0.001	.317	/	/		
1.000	+/-0.010	.1000	/	/		
0.250	+/-0.010	.250	/	/		
0.061	+/-0.010	.061	/	/		
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.231 ± .025	/	/		

<b>Measured by:</b>	<i>[Signature]</i>
<b>Date:</b>	10-4-14

<b>Audited by:</b>	<i>[Signature]</i>
<b>Date:</b>	10/04/15

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

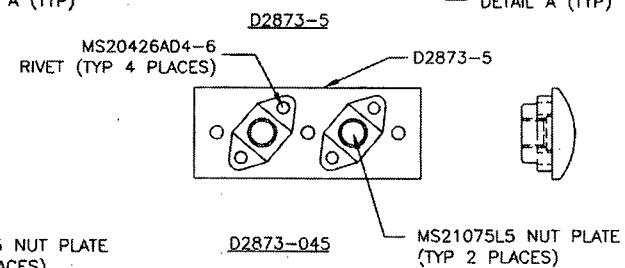
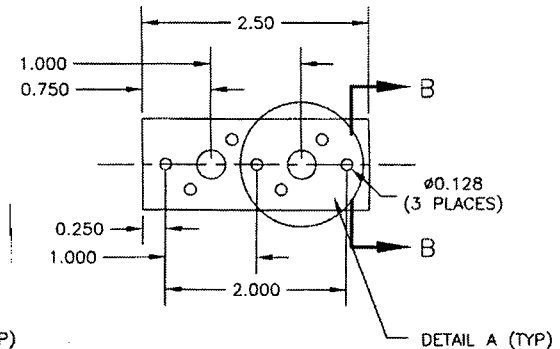
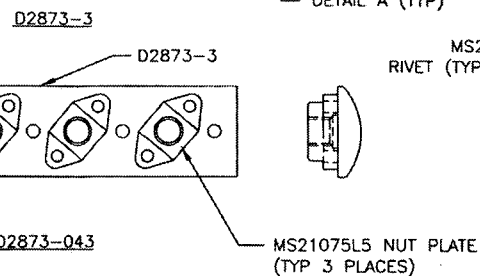
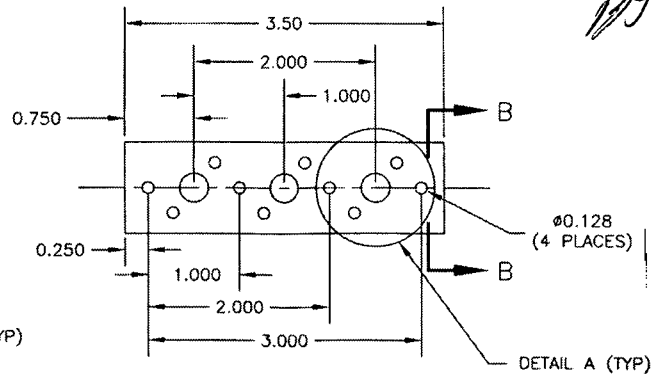
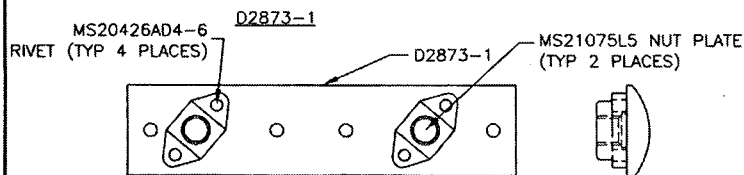
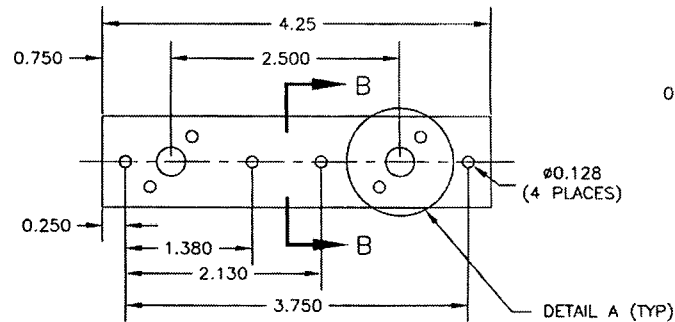
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 52337

10-11-05



D2873-041

**D2873-1/-3/-5 RADIUS BLOCK**

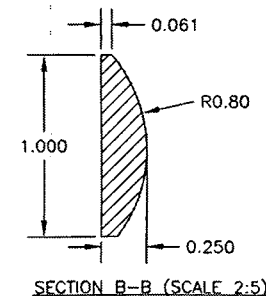
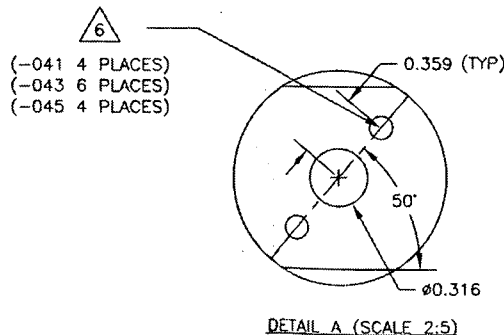
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

**D2873-041/-043/-045 NUT PLATE ASSEMBLY**

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

**D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST**

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED  
R 05-07-26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD WARRICKBURGH, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries